

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020470**Date Inspected:** 21-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng /Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 10 – Tower Shop

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 031 located on BK0010A2-001. Welder is identified as 040533. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 082 located on BK0010A2-001. Welder is identified as 053869. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 008 located on BK004A1-031. Welder is identified as 040533. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 038 located on BK004A1-031. Welder is identified as 053869. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Visual Inspection

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08249.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK007ASD1-001-001, 002, 003, 004, 022, 023, 024, 027

SA3342-001-001, 002

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08251.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK008A5-002-014, 015, 034, 035, 054, 055, 074, 075, 024, 025, 044, 045, 064, 065, 084, 085, 110, 111, 113, 114, 116, 117, 119, 120, 123, 124, 126, 127, 129, 130, 132, 133

BK008A6-002-063, 070, 080, 078, 090, 088, 100, 098, 061, 065, 076, 082, 086, 092, 096, 102

BK008A8-002-063, 070, 080, 078, 090, 088, 100, 098, 061, 065, 076, 082, 086, 092, 096, 102

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08255.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK005A-003-MEP-031, 032, 034, 035, 001, 004, 007, 010, 025, 026, 027, 028

BK004C-024-MEP-031, 032, 033, 034, 035, 001, 004, 007, 010, 013, 016, 019, 025, 026, 027, 028

BK004A-057-MEP-031, 032, 033, 034, 035, 001, 004, 007, 010, 013, 016, 019, 025, 026, 027, 028

BK004C3-024-073, 064

BK004C4-024-084, 079

BK005A3-003-073, 064

BK005A4-003-084, 079

BK004A3-057-073, 064

BK004A4-057-084, 079

Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08249.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

SA3342-001-001, 002

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

08251.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK008A5-002-014, 015, 034, 035, 054, 055, 074, 075, 024, 025, 044, 045, 064, 065, 084, 085, 110, 111, 113, 114, 116, 117, 119, 120, 123, 124, 126, 127, 129, 130, 132, 133

BK008A6-002-063, 070, 080, 078, 090, 088, 100, 098, 061, 065, 076, 082, 086, 092, 096, 102

BK008A8-002-063, 070, 080, 078, 090, 088, 100, 098, 061, 065, 076, 082, 086, 092, 096, 102

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08255.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK005A-003-MEP-031, 032, 034, 035, 001, 004, 007, 010, 025, 026, 027, 028

BK004C-024-MEP-031, 032, 033, 034, 035, 001, 004, 007, 010, 013, 016, 019, 025, 026, 027, 028

BK004A-057-MEP-031, 032, 033, 034, 035, 001, 004, 007, 010, 013, 016, 019, 025, 026, 027, 028

BK004C3-024-073, 064

BK004C4-024-084, 079

BK005A3-003-073, 064

BK005A4-003-084, 079

BK004A3-057-073, 064

BK004A4-057-084, 079

Ultrasonic Testing Inspection (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08249.

This QA inspector performed UT of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date.

The members are identified as:

BK007ASD1-001-001, 002, 003, 004, 022, 023, 024, 027

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Scott

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer